Work Order ID 107333 September-23-13 11:48:17 AM				*107			Page 1				
Item ID: Revision ID: Item Name:	D4124-1 Tab			Accept	*N900	040	100) * s	Setup Start	171	S1* S2*
Start Date: Required Date Reference:	9/23/13 : 9/23/13	Start Qty: 20.00 Req'd Qty: 20.00	7		Cust Item I. Customer:	D:			_		
Approvals:	Process Plan: Mして		Date: 13-09-25	Tooling: SPC (Y/N):	Date: Date:			F	Run Star Stop		R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr									
D4124	Α										
100				0.00							
100 Waterjet FLOW CNC Water	·jet	Memo 1-Cut as _I Dwg Rev Prog Rev	<u> </u>	0.00				20	O		13.11.0}
			if necessary								

0.00

0.00

QC2- Inspect parts off machine FAI/FAIB

Memo

110

110

Quality Control

											DQA:	Date:	
NCR: Y	'es /	No				WORK ORDER NON-C	CON	IFORN	MANCE / UP	DATE		_	
											QA Closed:	Date:	
Work Orde	· -					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
WOIK OIGE	'' —					Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	1		noforming	Finishing	4	re/Packaging	Other
NCR N	lo					Work Order Update			Large Fab	Composite		Supplier	
											_		
Root						ption of work order update	1	nitial		tion	Sign &	_	
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data		1		ĺ									·
Equip/Tooling		1					İ						
Operator													
Material													
Setup						•							
Other													
Process													
Supplier	\Box												
Training													
Unapproved													
						F.	AUL	T CATE	GORY				
Landi	ng Ge	ar				General					_		
	В	ending				Bend		Grain			Ovalized		Pressure/Forced
	C	entre No	t Concer	ntric to (o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
		racks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
	C	rushed/0	Crimped			Burrs		Instruct	ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled

Maintenance

Out of Calibration
Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio Part Moved

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Work Order ID 107333 *107333* September-23-13 11:48:17 AM Accept *N900040100* Setup Start Item ID: D4124-1 Revision ID: Tab Item Name: **Start Qty: 20.00** *20* 9/23/13 Cust Item ID: **Start Date:** Reg'd Oty: 20.00 Required Date: 9/23/13 **Customer:** Reference: Run Date: Tooling: Date: Process Plan: Approvals: Stop SPC (Y/N): Date: Date: OC: Reject Tool ID Tool # Plan Set Up/ Accept Sequence ID/ Operation Qty Work Center ID **Run Hours** Code Qty Description OC8- Inspect parts - second check 0.00 120 DAS 27 *120* 9-89 0.00 Memo B10-18 Quality Control Identify as per dwg & Stock Location: WAO23 0.00 130 *120*

140

Packaging

Packaging

OC21- Final Inspection - Work Order Release

0.00

140

Memo

Memo

Quality Control

1 pl/3-11-11

0.00

Page 2

Reject Number Stamp

Insp.

0.00

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: AGAINST DEPARTMENT/PROCESS **DISPOSITION** Work Order: Skid-tube Engineering Crosstube Water Jet Rework Quality Small Fab Prod. Eng. Coor. Machining Part No. Scrap Thermoforming Finishing Rec/Store/Packaging Other Use-as-is Supplier Work Order Update Large Fab Composite NCR No. Description of work order update Action Sign & Initial Root or Non-conformance Chief Eng Description Date Verification QC Inspector Date Qty Cause Step Doc/Data Equip/Tooling Operator Material Setup Other

Unapproved **FAULT CATEGORY Landing Gear** General Ovalized Pressure/Forced Bend Grain Bending BOM/Route Temperature/Cure Over/Under tolerance Centre Not Concentric to O/S Hardware Broken/Damaged Inspection Incomplete Cracks Part Incorrect Weld Crushed/Crimped Wrong Stock Pulled Burrs Instructions Incomplete/Unclear Part Lost/Missing Cuffs Maintenance Part Moved Contamination Heat Treat Countersink Mislabeled Positioned Wrong Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other **Drill Holes** Ripples in Bend Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Wave/Twist in Tube Folio **Outside Dimensions**

Process Supplier Training September-23-13 11:48:17 AM

Page 1

Work Order ID:

107333

Parent Item:

D4124-1

Parent Item Name:

Tab

Start Date: 9/23/13

Required Date: 9/23/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A 10.07.21 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet	•	Purchased	No			100	sf	421.6005	0.03125	0.6578947	Au	13:1	1.08
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT021		421.6005							
				123	135	120.2625							
				124	003	72.113					_	1.0	8
				M12	26075	229.225			120	0075 -		,60	o

									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	ONFO	RMANCE / U	PDATE	QA Closed:	Date:	
Work Orde					DISPOSITION			AGAINST DI	1		
Work Order: Part No.			Rework Scrap		Skid-tube Crosstube Machining Small Fab		Water Je		Engineering Quality		
NCR N	lo		-		Use-as-is Work Order Update	The	rmoforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	, A	Action	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief E	ng De	scription	Date	Verification	QC Inspector
Doc/Data											·
quip/Tooling										1	
Operator											
Material [-					ļ	
Setup		ļ	•								
Other		İ									
Process										ļ	
Supplier											
Training											
Unapproved											
					F.	AULT CA	TEGORY				
Landi	ng Gear				General						-
	Bending				Bend	Grai	n		Ovalized		Pressure/Forced
i	Centre I	Not Conce	ntric to	o/s	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspe	ection Incomplete		Part Incorre	ct	Weld
	Crushed	/Crimped			Burrs	Instr	uctions Incomplet	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mai	ntenance		Part Moved		
	Heat Tre	eat			Countersink	Misla	abeled		Positioned \	Wrong	_
	Inspecti	on Strip in	1 Tube		Cut Too Short	Misr	ead		Power Loss	/Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

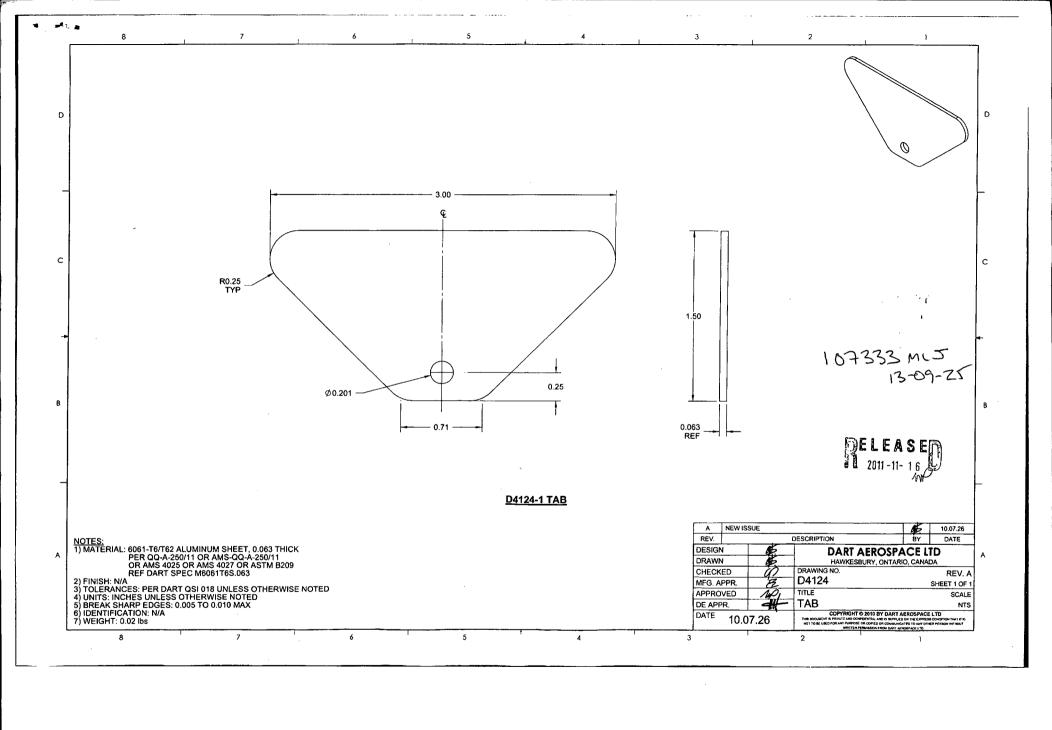
DART AEROSPACE LTD	Work Order:	107333
Description: Tab	Part Number:	D4124-1
Inspection Dwg: D4124 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

D											
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments					
Ø0.201	+0.005/-0.001	,204			V	JKM-01					
0.25	+/-0.030	.25	_		V						
3.00	+/-0.030	2,99	_		V						
1.50	+/-0.030	1,50	_		v						
0.063	+/-0.010	1059			V						
PACE AND ADDRESS OF THE PACE A											

Measured by: Ac Audited by: 27 Preliminary Approval: Date: 31108 Date:

Rev	Date	Change	Revised by Approved
Α	12.05.15	New Issue	KJ ()
			7/1 7 /



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